**Work Order ID 85428** ASAP *85428* 

*June-07-12 2:55:10 PM*

**Item ID:** D3396-3 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:**

**Item Name:** Spacer **Stop** *NS2*

**Start Date:** 07/06/2012 **Start Qty:** 30.00 *30* **Cust Item ID:**

**Required Date:** 14/06/2012 **Req'd Qty:** 30.00 *30* **Customer:**

**Reference:**

**Approvals:** **Process Plan:** MLJ **Date:** 12/06/07 **Tooling:** **Date:** **Run Start** *NR1*

**QC:** **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|---|
| **Draw Nbr** D3396 | **Revision Nbr** Rev B | | | | | | | | | |
| 100 *100* Hardinge Hardinge CNC Lathe Small | Hardinge CNC LATHE SMALL **Memo** Turn as per Folio FA514 and Dwg D3396Deburr | 0.00 0.00 | SL 12-06-09 | | | | 30 | | | |
| 110 *110* QC Quality Control | QC2- Inspect parts off machine FAI/FAIB **Memo** | 0.00 0.00 | SL 12-06-09 | | | | | | | |
| 120 *120* QC Quality Control | QC8- Inspect parts - second check **Memo** | 0.00 0.00 | SL 12/6/9 | | | | 30 | Ø | | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

# Work Order ID 85428

*June-07-12 2:55:10 PM*

*85428*



**Item ID:** D3396-3
**Revision ID:**
**Item Name:** Spacer

**Accept** *N900040100*

**Setup** **Start** *NS1*
**Stop** *NS2*

**Start Date:** 07/06/2012 **Start Qty:** 30.00 *30*
**Required Date:** 14/06/2012 **Req'd Qty:** 30.00 *30*
**Reference:**

**Cust Item ID:**
**Customer:**

**Approvals:** **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______
**QC:** ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

**Run** **Start** *NR1*
**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 *130* Packaging | Identify as per dwg & Stock Location 5741 | 0.00 | | | | 30 | | Sue 12/06/11 | |
| Packaging | Memo | 0.00 | | | | | | | |
| 140 *140* QC | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | 12/6/11 | |
| Quality Control | Memo | 0.00 | | | | | | | |

MS
12-06-29

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: ________________ PAR #: _______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ________________ Disposition: ________________ QA: N/C Closed: _________ Date: _________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| | | | Corrective Action Section B | | | | | |
| DATE | STEP | Description of NC Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

# Picklist Print

*June-07-12 2:55:14 PM*



T

**Work Order ID:** 85428

*85428*

**Parent Item:** D3396-3

*D3396-3*

**Parent Item Name:** Spacer

**Start Date:** 07/06/2012 **Required Date:** 14/06/2012

**Start Qty:** 30.00 **Required Qty:** 30.00

**Comments:** IPP A05.10.03New issueKJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| MDELRINR0.750 | | Purchased | No | | | 110 | f | 150.6450 | 0.0625 | 1.973684 | | | |

*MDELRINR0.750*

Delrin Round Bar 0.75"

** SL 12-06-09

| Location | | Loc Qty | Loc Code | |
|---|---|---|---|---|
| MAT055 | | 150.645 | | |
| | 116183 | 2.4 | | |
| | 117273 | 1.555 | | |
| | 117322 | 0.94 | | |
| | 120722 | 5.28 | | |
| | 121783 | 140.47 | | 2.0 |

Dart Aerospace Ltd

| W/O: | WORK ORDER CHANGES | | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

**Resolution:** ______________ **Disposition:** ______________ **QA: N/C Closed:** __________ **Date:** _________

| NCR: | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

| DART AEROSPACE LTD | Work Order: | 85428 |
|---|---|---|
| | | |
| Description: Spacer | Part Number: | D3396-3 |
| | | |
| Inspection Dwg: D3396 Rev: B | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| 0.226 | +/-0.010 | .223 | ✓ | | Vern | >L-10 |
| Ø0.313 | +0.005/-0.000 | .316 | ✓ | | \| | |
| Ø0.740 | +/-0.010 | .739 | ✓ | | \| | |
| 0.032 x 45° | +/-0.010 | .03x45° | ✓ | | \| | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| Measured by: | SL | Audited by: | SL | Prototype Approval: | N/A |
|---|---|---|---|---|---|
| Date: | 12-06-09 | Date: | 12/6/9 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | 06.03.09 | New Issue | KJ/JLM | [signature] |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ____________________ **PAR #:** _______ **Fault Category:** ____________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

**Resolution:** ____________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

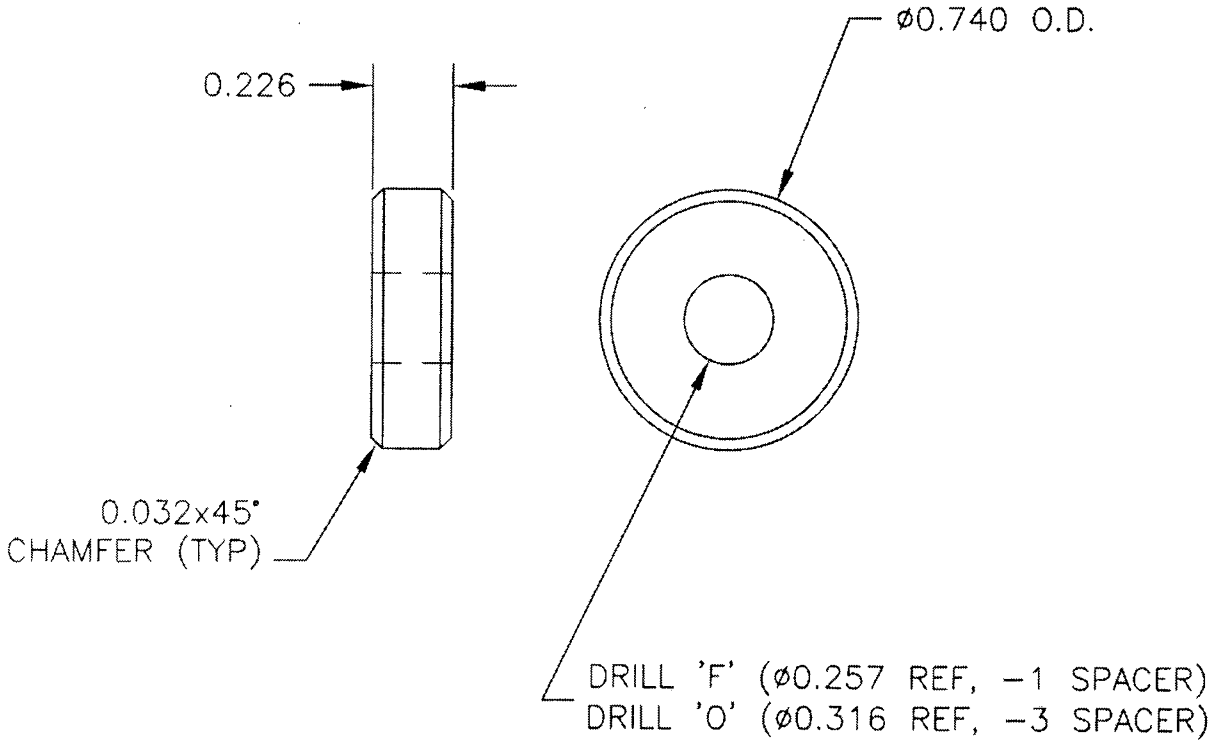
**NOTE:** Date & initial all entries

DART

| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
|---|---|---|
| CHECKED [signature] | APPROVED [signature] | DRAWING NO. D3396 — REV. B — SHEET 1 OF 1 |
| DATE 05.04.27 | | TITLE SPACER — SCALE 2:1 |

| | | |
|---|---|---|
| A | 05.03.10 | NEW ISSUE |
| B | 05.04.27 | ADD −3 |

05.09.06 [initials]




SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85428 MCJ
12/08/07

**D3396−1/−3 SPACER**

1) MATERIAL: DELRIN (DART SPEC. M−DELRIN−R)
2) FINISH: NONE
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval<br>Chief Eng / Prod Mgr | Approval<br>QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** ______________ **PAR #:** ______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** ________

**Resolution:** ______________ **Disposition:** ______________ **QA: N/C Closed:** ________ **Date:** ________

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| DATE | STEP | Description of NC<br>Section A | Corrective Action Section B | | | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
| | | | Initial<br>Chief Eng | Action Description<br>Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries